

Date: Thursday, 05/02/2009 3:46:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP (CASTING DETAIL)
Job Number : 45553	
Estimate Number : 11088	
P.O. Number :	Part Number : D25761
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D2576 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : G
Previous Run : 43534	Material :
Written By :	Due Date : 20/02/2009 Qty: 100 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC Est Rev:C As per Rev G 07-09-05 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8157

Ship D2576 mould to vendor

Cast per D2576-1 Pattern

Material Release Note Required

C 2091102106100

2.0	D25761P	Step (Casting Detail)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
 STEP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure D2576 mould is returned with the ordered parts

Ensure release note is attached

100

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK809100106

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: CNC Location88 09/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP (CASTING DETAIL)

Job Number: 45553

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 JF

Job Completion



MF 09-03-09

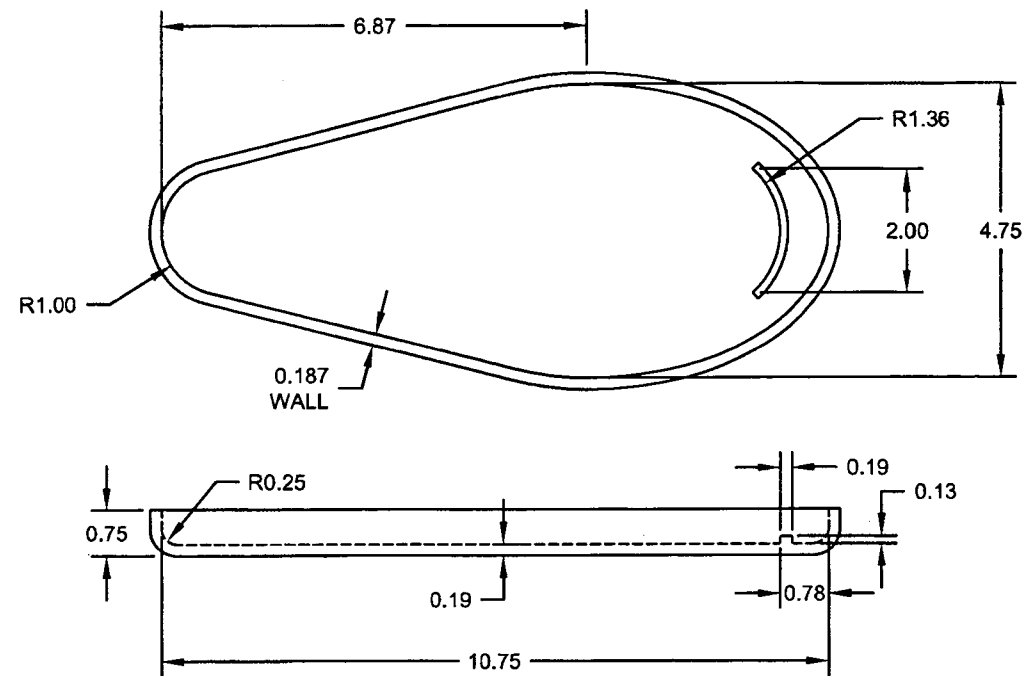
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

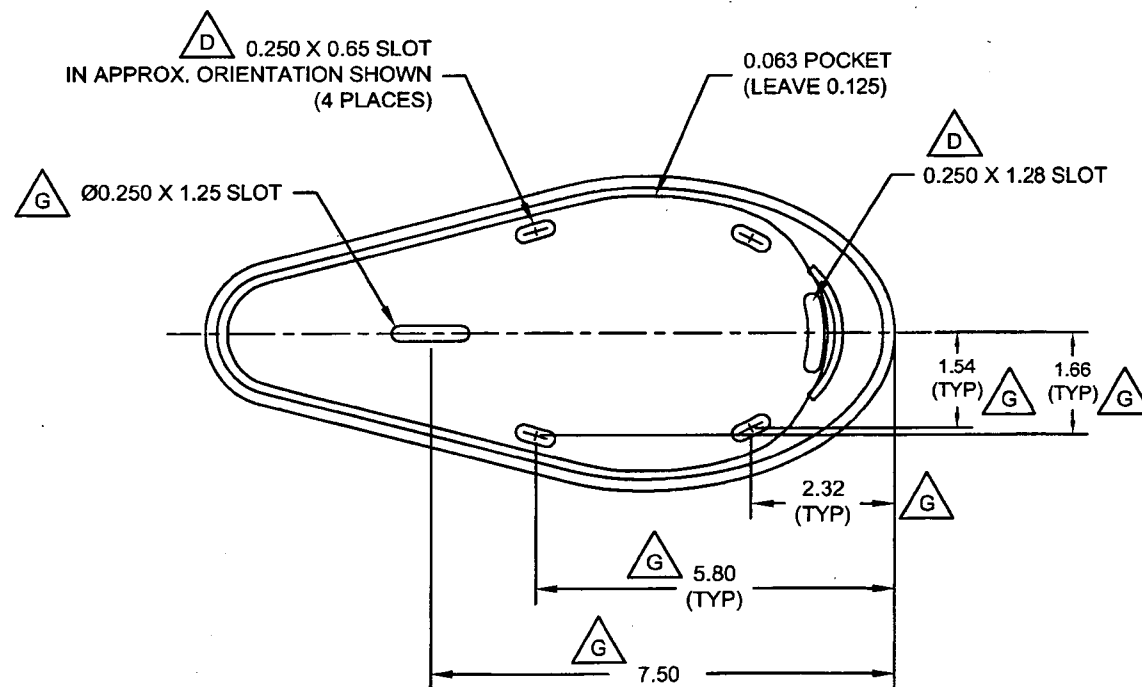
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15553

RELEASED

07.08.29

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. G	
MFG. APPR.	<i>[Signature]</i>	D2576 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	STEP 1:3	
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via		Page
06-Feb-2009		PO0008157	20-Feb-2009	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship
1 2	DART D2576	D2576 STEP CSTG		100		100
S 09/02/26						

Comments

Castings&Patterns are property of Alpine until paid in full

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
1849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE NOV 05 2008

CONFORMS TO ASTM SPECIFICATION: B179-06

Sil
0102/26

Lot: 535.2

Item: a8297

S 0.075
P 0.087
C 0.005
Mn 0.173
Mg 7.380

C 0.001
Zn 0.050
Ti 0.146
Si 0.004
Pb 0.001
Ni 0.001

CF < .15
S 0.000

A REMAINDER

Si .10
Fe .10
Cu .05
Mn .10-.25
Mg 6.6-7.5

Cr
Zn .05
Ti .10-.25

Sn
Pb
Ni
OET .15

Sr
Al REMAINDER

BE 004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakrzewski

NOV 05 2008

RON ZAKRZEWSKI

DATE

LAB MANAGER

Version 1.0-12/2007

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.